

Date: Wednesday, 1/30/2008 7:48:58 AM
 User: Kim Johnston

Process Sheet

12

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 STEP ASSEMBLY, SHORT HIGH SKID
 Job Number : 37046
 Estimate Number : 10460
 P.O. Number :
 This Issue : 1/30/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D350591113
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2310 REV D
 Previous Run : 35271 Drawing Revision : D
 Material :
 Due Date : 3/20/2008 Qty: 14 Um: Each
 Written By :
 Checked & Approved By : 08 01 30
 Comment : Est Rev: 04.11.09 Reformat KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-591-113 CHG003

08/03/08

2.0 D2244116 Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2244 Step Extrusion B33723

SAD 08/03/04

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310

2-Drill extrusion as per Dwg D2310 using drill Jig DT8230

3-Deburr

08.03.06
SAD 08/03/04

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/06 14

5.0 D267334 End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2673-34

End Cap B32404 = 4

B35887 = 24

08.03.07 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:48:58 AM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 37046

Part Number: D350591113

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2275	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number

1 D2275

Description Batch

Bushing 27755

PE 08-03-07 14

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd end cap and bushing as per Dwg D2310

A/R AL ROD Batch: ~~87755~~ M105058
M106762

2-Grind end cap and bottom bushing welds flush SAD 08/03/08

3-Machine top weld on bushing flush

PE 08-03-07 14

PE 08-03-10 14

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 08-03-10 (14)

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/03/10 (14)

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H 08/03

(14X)

11.0	MS20600AD4W3	Cherry Rivets
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 224.0000 Each(s)

Pick:

Qty Part number Description

16 MS20600AD4W3 Rivet

Batch

M-102929

SAD 08/03/11 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:48:58 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP ASSEMBLY, SHORT HIGH SKID

Job Number: 37046

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

D2582

Hi-Skid Step Leg Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description

Batch

1 D2582

Step Leg Assembly

B36710(3)
B37452(11)

SAD 08/03/10 (14)

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet as per Dwg D2310

SAD 08/03/11 (14)

2-Inspect for foreign object as per QSI 024

3-Weld Aft end cap as per Dwg D2310

A/R AL ROD Batch: M105058

4-Grind end cap welds flush

pk 08.03.11

pk 08.03.12

pk 08.03.12

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

pk 08.03.12 (14)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

pk 08/03/12 (14)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

M-L

08/03/12

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107005

M-L

08/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ✓ Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Wednesday, 1/30/2008 7:48:58 AM
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Job Number: 37046

Part Number: D350591113

Job Number:



Seq. #: Machine Or Operation: Description:

18.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2310 and QSI 005 4.4

Batch: M 107385

BR 08-03-14

(14X)

19.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION AND WING WALK

M 08/03/14

(14X)

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 K591113 Short Step Instln Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick Packing Kit:

Qty Part number

Description Batch

1 K591-113

Hardware Kit

1337456

SL

22.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/03/14

(14X)

23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-113

Location: Rev I

AS 08/03/14

(14X)

24.0 QC21 FINAL INSPECTION/W/O RELEASE:



Comment: FINAL INSPECTION/W/O RELEASE

08/03/14

(14)

Job Completion



mi 2008/3/18

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2310	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37046

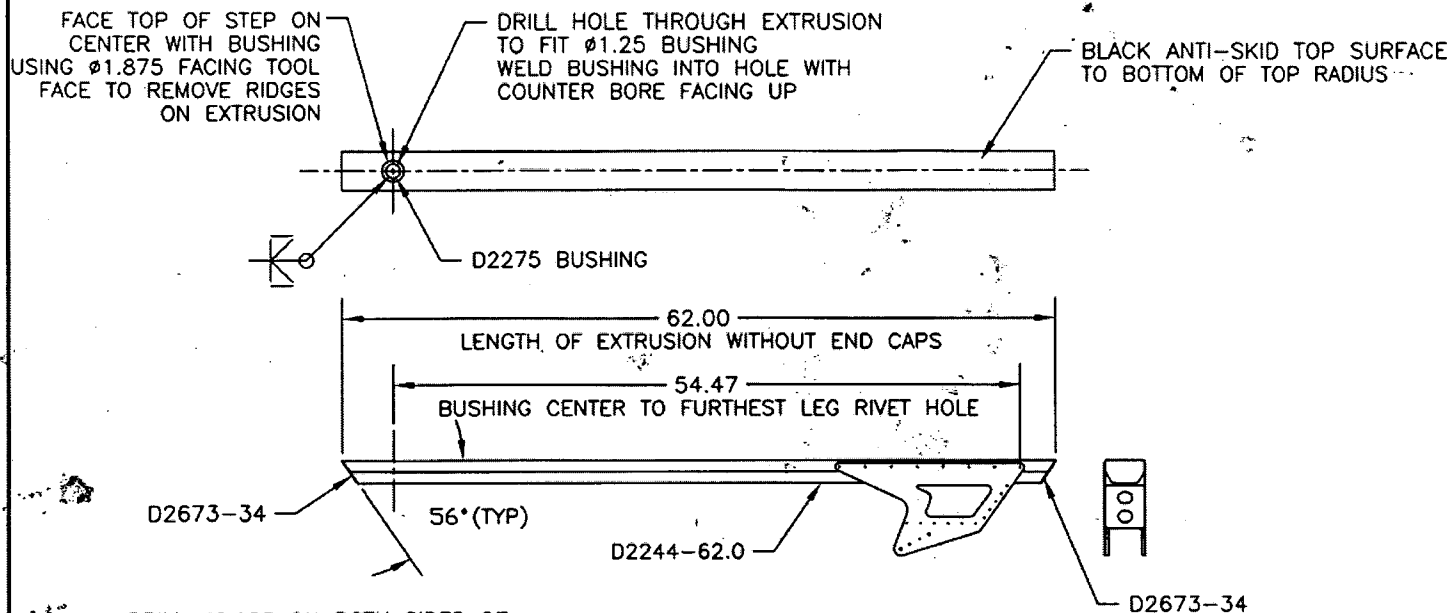
RELEASED
05.11.28 *[Signature]*

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DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2310
DATE	TITLE	REV. D
05.11.14	HIGH SHORT STEP ASSEMBLY	SHEET 2 OF 2
		SCALE
		NTS



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK-ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 100410
WORK ORDER
RELEASED
05.11.28

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

DART AEROSPACE LTD		Work Order :	37046
		Description:	Inspection/Labels
			D350.591-113
		Approval :	U
			Page 1 of 1

Please scan & attach
to original W/O.

Step	Location	Process	By	Date																																												
1	PK	Removal Qty: 13 Part Number: D350.591-113 Description: CHS Batch: 37046 Thanks!! 79 Jason, 1	U	10.06.25																																												
2	DC	Re-work/Inspection: Create new red decs to reflect CHS 004 per W/O 10-079	U	10.06.25																																												
	QC4	Inspect labels	U	13 10.06.25																																												
3	PK	Identify & Stock: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td></td> <td></td> <td>N/A</td> <td>U</td> </tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> <tr><td></td><td></td><td></td><td></td></tr> </tbody> </table>	Qty	Part Number	Description	Batch			N/A	U																																						
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